

Work Order ID 60621

Thursday, July 15, 2010 10:27:43 AM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly (350)

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-7-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	B V/R	PROCEED - 10.07.15							
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10.7.26 J

5/10/07/27 D

5/10/07/27

(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60621

Thursday, July 15, 2010 10:27:43 AM

Page 2

Item ID: D4030-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010 Start Qty: 1.00

Required Date: 7/22/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-27 SF

10/07/29

10-7-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:27:48 AM

Page 1

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)





Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	17.0000	1	1			
<div> <div>Location</div> <div>ST506</div> <div>59637</div> <div>60206</div> </div> <div> <div>Loc Qty</div> <div>17</div> <div>7</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2535  Spring		Manufactured	No			100	Each	102.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>56355</div> <div>58331</div> </div> <div> <div>Loc Qty</div> <div>102</div> <div>2</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2537  Bushing		Manufactured	No			100	Each	41.0000	4	4			
<div> <div>Location</div> <div>ST504</div> <div>9</div> <div>58429</div> <div>59122</div> <div>59423</div> </div> <div> <div>Loc Qty</div> <div>41</div> <div>1</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1				

B60622 (10)

ES 10/07/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Thursday, July 15, 2010 10:27:48 AM

Page 2

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3914-041

Manufactured No

100

Each

0.0000

1



Long Basket Lid Assembly (350)

B60624 (12)



Escop 7/27

D3917-3

Manufactured No

100

Each

25.0000

6



Washer



B60298 10-7-26

Location

Loc Qty

Loc Code

ST095

12

60298

12

ST096

13

57144

1

58892

12

D3953-3

Manufactured No

100

Each

22.0000

2



Gas Spring Stud, Lid



10-7-26

Location

Loc Qty

Loc Code

ST102

22

58894

2

59437

20

D3953-7

Manufactured No

100

Each

22.0000

2



Spring Spacer



10-7-26

Location

Loc Qty

Loc Code

ST103

22

58893

2

59438

20

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100 Each

34.0000

2

2



Gas Spring Washer



10-7-268

Location

Loc Qty

Loc Code

ST101

14

53642

2

59147

12

ST103

20

60008

20

2

D3953-17

Manufactured No

100 Each

28.0000

2

2



Gas Spring Spacer



10-7-268

Location

Loc Qty

Loc Code

ST101

28

57143

1

59197

27

2

D3953-19

Manufactured No

100 Each

16.0000

1

1



Gas Spring Bracket



B39213 10-7-268

Location

Loc Qty

Loc Code

ST101

2

57607

2

ST103

14

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 15, 2010 10:27:48 AM

Page 4

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-21

Manufactured No

100 Each

24.0000

1

1



Gas Spring Bracket



10-7-268

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

19

57145

2

59214

17

D3969-3

Manufactured No

100 Each

9.0000

1



Spring (Basket Lid)



10-7-268

Location

Loc Qty

Loc Code

ST

9

56386

1

58986

8

AN3-14A

Purchased No

100 Each

122.0000

4

4



Bolt



10-7-268

Location

Loc Qty

Loc Code

ST351

122

114330

22

114941

50

115108

50

Thursday, July 15, 2010 10:27:48 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No 100 Each 126.0000 2 2
Bolt

Location	Loc Qty	Loc Code
ST352	126	
113845	6	
114523	20	
114752	100	



10.7.268

AN5-17A Purchased No 100 Each 119.0000 4 4
Bolt

Location	Loc Qty	Loc Code
ST339	119	
114330	73	
114784	46	



10.7.268

AN4-12 Purchased No 100 Each 52.0000 3 3
Bolt

Location	Loc Qty	Loc Code
ST357	52	
114292	2	
114784	50	



10.7.268

AN310-4 Purchased No 100 Each 53.0000 3 3
NUT

Location	Loc Qty	Loc Code
ST324	53	
114716	3	
115107	50	



10.7.268

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 6

Work Order ID: 60621

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010


Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00


AN310C4

 Nut

Purchased No 100 Each 50.0000 2 2


 10-7-26-2

Location Loc Qty Loc Code

ST349 50
 114306 50


MS21042L3

 Nut

Purchased No 100 Each 2,684.000 6 6


 10-7-26-2

Location Loc Qty Loc Code

ST300 2684
 112385 4
 114523 204
 114718 476
 114784 2000


MS21042L5

 Nut

Purchased No 100 Each 893.0000 4 4


 M103446 10-7-26-2

Location Loc Qty Loc Code

ST139 393
 114813 393
 ST300 500
 115156 500

MS24665-151

 Cotter Pin

Purchased No 100 Each 634.0000 3 3

 10-7-26-2

Location Loc Qty Loc Code

ST309 634
 17566 634

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Page 6

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 7

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

60.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

60

105279

2

110123

58

NAS1149F0432P

Purchased

No

100

Each

420.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST275

420

112940

92

114405

1

114576

10

114718

317

NAS1149F0563P

Purchased

No

100

Each

212.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST275

12

108471

12

ST298

200

114576

200

NAS1149F0332P

Purchased

No

100

Each

691.0000

8

8



WASHER

Location

Loc Qty

Loc Code

ST275

691

18057

691

Thursday, July 15, 2010 10:27:48 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, July 15, 2010 10:27:48 AM

Page 8

Work Order ID: 60621

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

730.0000

2

2



Washer

10-7-2010

Location

Loc Qty

Loc Code

ST297

730

114292

140

114742

590

2

Thursday, July 15, 2010 10:27:48 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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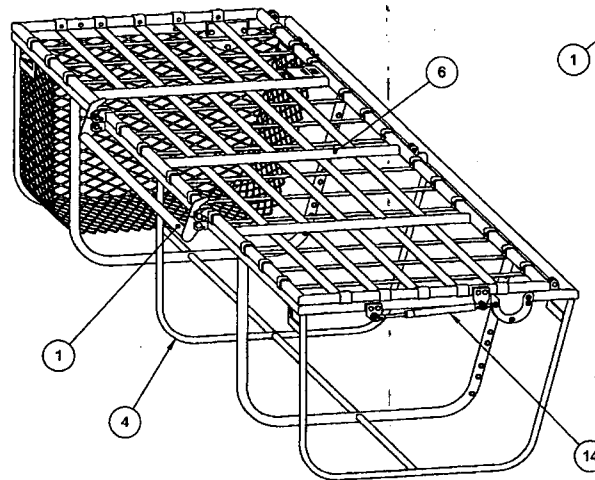
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

10.07.15

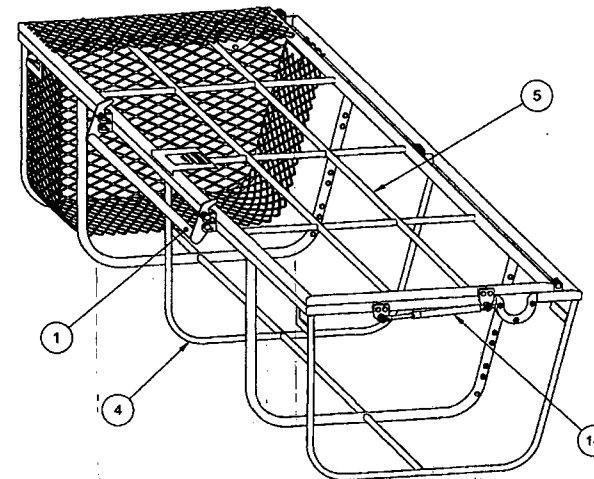
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60621
R/10-7-15



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

UNDER REVIEW

10.06.16
-043 MISSING QTY
FOR NDM 30, 31

RELEASED
2010-04-14

PROCESSED
10.07.15

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	AM		
DE APPR.	AM		
DATE	10.04.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. B
SHEET 1 OF 3
TITLE **LONG BASKET ASSY (350)** SCALE NTS

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Dart Aerospace Ltd

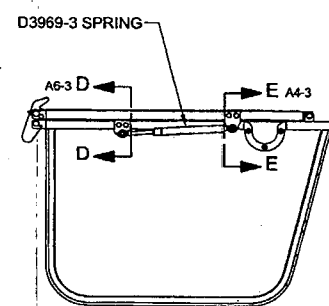
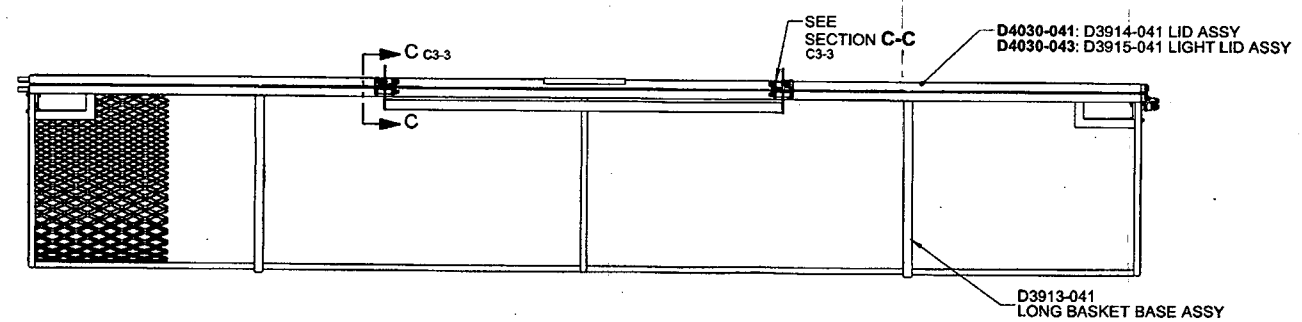
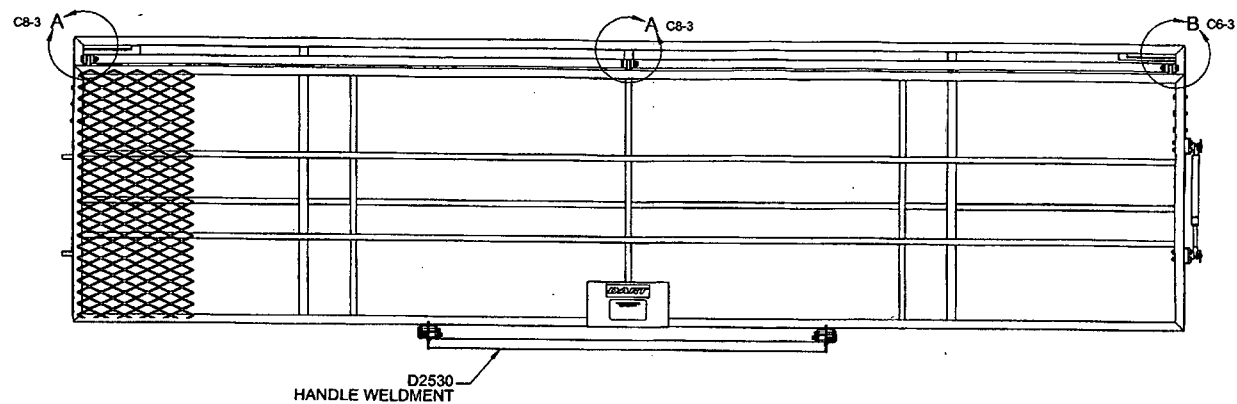
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
2010-04-14

D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

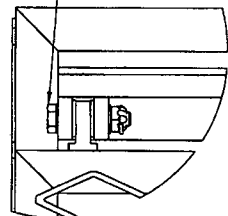
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

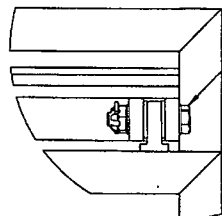
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

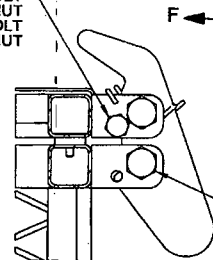


DETAIL A D8-2
D5-2



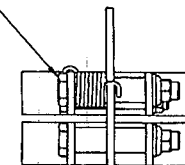
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	GP	D4030	SHEET 3 OF 3
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries